

Work Order ID 87508***87508***

Page 1

July-19-12 11:11:29 AM

Item ID: D3648-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Driveshaft Tunnel Assembly
Start Date: 7/10/12 Start Qty: 2.00 ***1*** Cust Item ID:
Required Date: 8/10/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/07/20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3648	Rev B								

100 Pick Kit 0.00

100

Packaging Memo 0.00
Packaging

2 FF 12-11-29

110 Small Fab 0.00

110

Small Fab Memo 0.00
Small Fab 1-Assemble as per dwg D36482- Seal mating surface and all gaps as per dwg
D3648 with Proseal 700 fire wall sealant batch: 123727

2 FF 12-11-29

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00
Quality Control

AS
15
12-12-06

2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
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Material <input type="checkbox"/>												
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Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Page 2

July-19-12 11:11:29 AM

Item ID: D3648-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Driveshaft Tunnel Assembly
 Start Date: 7/10/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo P192817	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten signatures and dates:
 12/12/13
 ME
 12-12-12

NCR: Yes / No

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July-19-12 11:11:29 AM

Required Qty: 1.00

Comments:	IPP Rev:A	New Issue	07-10-03	EC	verified by: DD
	IPP Rev:B	Ecn 1113P	08-01-22	DD	verified by:EC
	IPP Rev:C	ECN1162	08-04-02	DD	verified by:EC

Component Item IL/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A Bolt		Purchased	No			110	Each	495.0000	40	40		FF 12-11-29	
				<u>Location</u>		<u>Loc Qty</u>							
				GA	123 203	70				80			
					118352	70							
				ST350		425							
					120187	1							
					122141	424							
D3649-041 Tunnel Bottom Panel Assembly		Manufactured	No		89484 90387	110	Each	0.0000	1	1		FF 12-11-29	
D3650-041 Tunnel Top Panel Assembly		Manufactured	No		94207	110	Each	0.0000	1	2		FF 12-11-29	
D3651-041 Aft Base Assembly		Manufactured	No		92868	110	Each	0.0000	1	1		FF 12-11-29	
NAS1149C0363R Washer		Purchased	No		87266	100	Each	5,005.0000	40	40		FF 12-11-29	
				<u>Location</u>		<u>Loc Qty</u>							
				297		2000							
					122441	2000							
				ST297		3005							
					114742	2805				80			
					122063	200							

NCR: Yes / No

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 87508 MLJ

12/07/20

AN3C-3A BOLT (1)
AN960C10 WASHER (1)
(26 PLACES)

NO SEALANT BETWEEN
THESE FLAT SURFACES

AN3C-3A BOLT (1)
AN960C10 WASHER (1)
(14 PLACES)

D3650-041
TUNNEL TOP PANEL ASSY

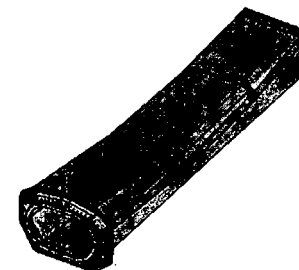
D3649-041
TUNNEL BOTTOM PANEL ASSY

D3651-041
AFT BASE ASSEMBLY

D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

NOTES:

- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED
08.03.27/10

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. REV. B D3648 SHEET 1 OF 1	
CHECKED	RF	TITLE SCALE DRIVE SHAFT TUNNEL ASSY 1:6	
MFG. APPR.	RF	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	RF		
DATE	08.01.07		

NCR: Yes / No

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